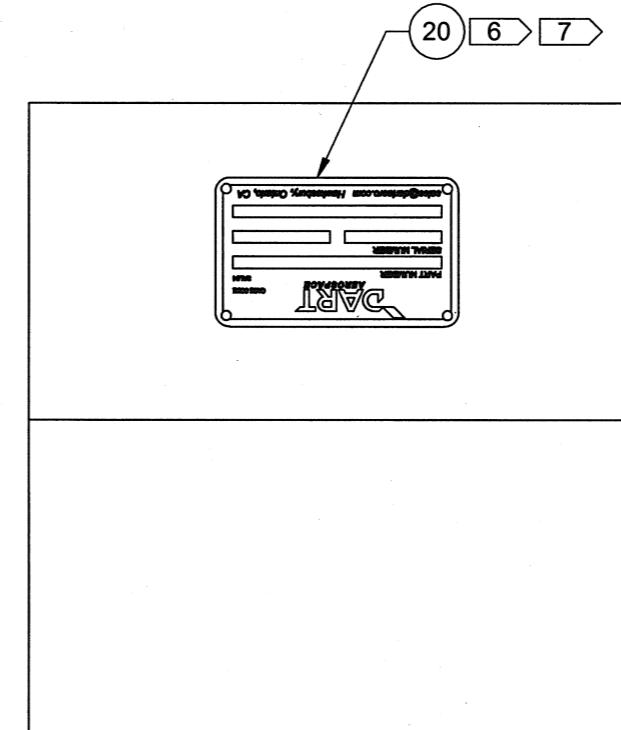
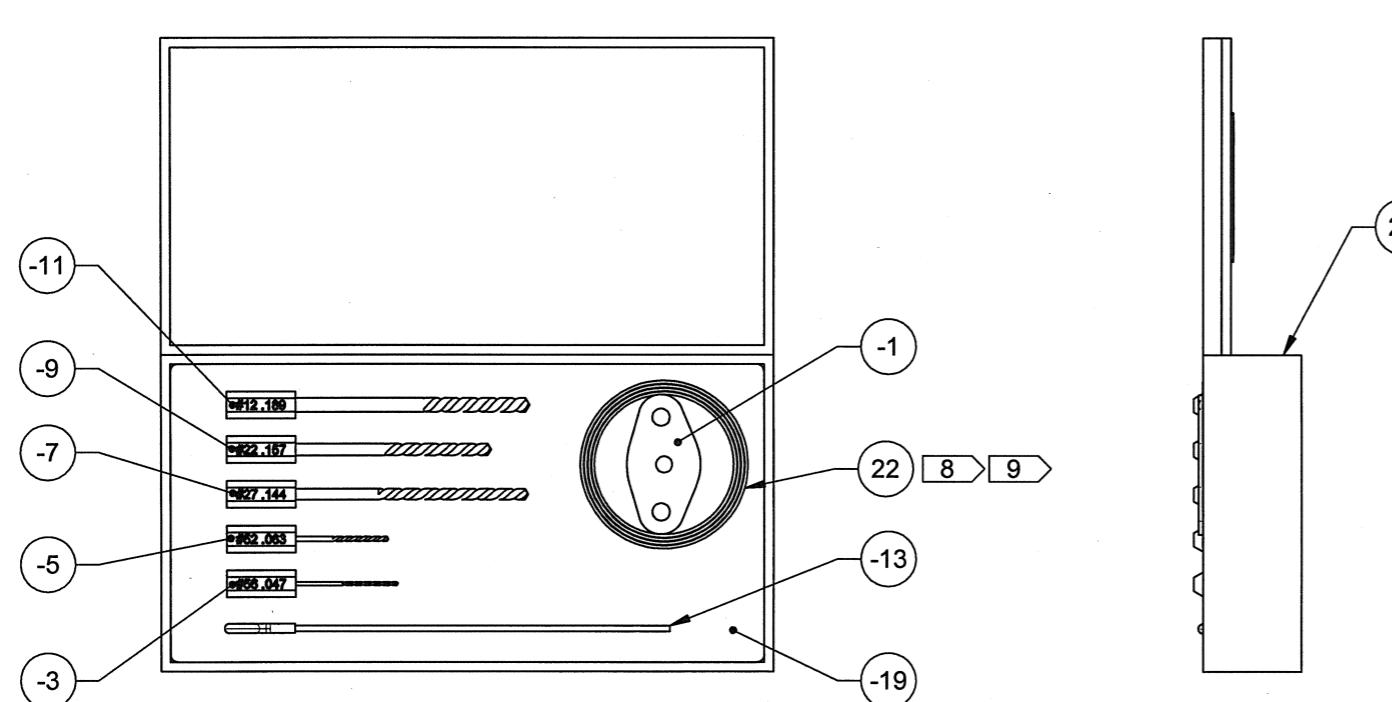


ITEM #	QTY	PART #	PART TITLE
-1	1	RB23003267-1	GUIDE
-3	1	RB23003267-3	#56 DRILL BIT ASSEMBLY
-5	1	RB23003267-5	#52 DRILL BIT ASSEMBLY
-7	1	RB23003267-7	#27 DRILL BIT ASSEMBLY
-9	1	RB23003267-9	#22 DRILL BIT ASSEMBLY
-11	1	RB23003267-11	#12 DRILL BIT ASSEMBLY
-13	1	RB23003267-13	SAW
-19	1	RB23003267-19	CRAFT FOAM
20	1	RB41011	DART PLACARD
21	1	FLAMBEAU #K206	CLEAR PLASTIC CASE
22	1	McMaster#8860K15 OR EQUIV.	304 SS SAFETY-WIRE 0.041" DIA. X 55' LG



### RB23003267 POWER TURBINE CLEANING KIT C-18, C-20 & C-28

NOTES:  
 1) MATERIAL: N/A  
 2) HEAT TREAT: N/A  
 3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
 X.XX = +/- 0.01" / +/- 0.5°  
 X.XXX = +/- 0.005" / +/- 0.1°  
 X.XXXX = +/- 0.0005" / +/- 0.05°  
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED  
 6) IDENTIFICATION: ENGRAVE THE TOOL P/N ON THE DART PLACARD WHERE INDICATED  
 7) HOT GLUE THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA  
 8) CUT ITEM 22 TO 48.00" +/- 1.00"  
 9) COIL ITEM 22 APPROX. AS SHOWN

SEE PREVIOUS REVISION FOR MORE INFORMATION UPDATED DRAWING TEMPLATE ADDED ITEM 20 -1 MATERIAL WAS 6061 IS 6061-T6 / 7075-T6 DRILL BIT ASSEMBLY ADDED TABLE 1 DRILL BIT ADDED TABLE 2 BLOCK ADDED TABLE 3. MATERIAL WAS 2011 IS 6061-T6 / 7075-T6		19-711	MBB	
REV.	DESCRIPTION		ECN #	BY
DESIGN	MBB	DART AEROSPACE LTD		
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA		
CHECKED	KPT	REV. E		
MFG. APPR.	FK	SHEET 1 OF 7		
APPROVED	VJF	TITLE POWER TURBINE CLEANING KIT C-18, C-20 & C-28 NTS		
DATE 4/30/2019		SCALE		
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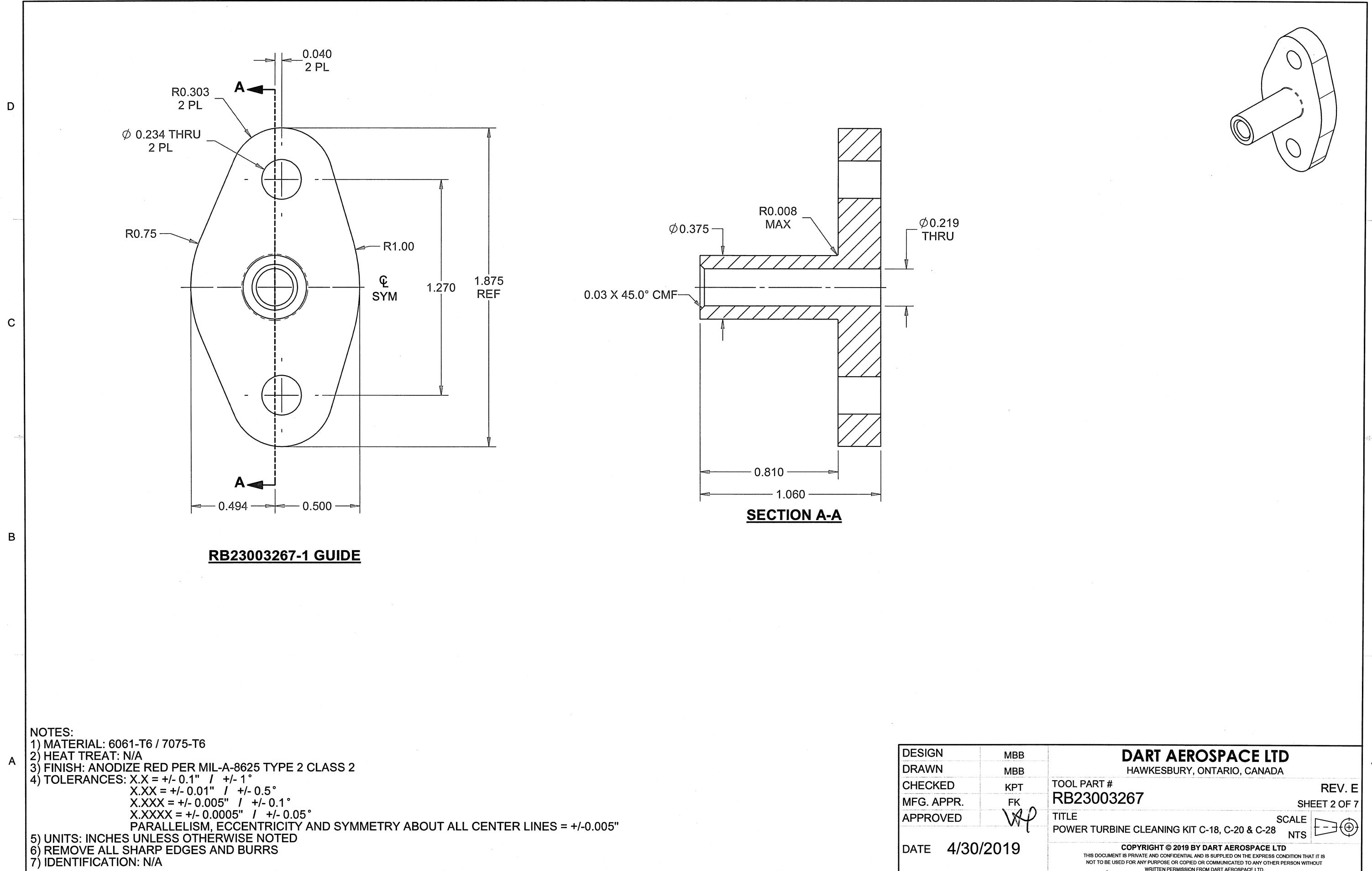
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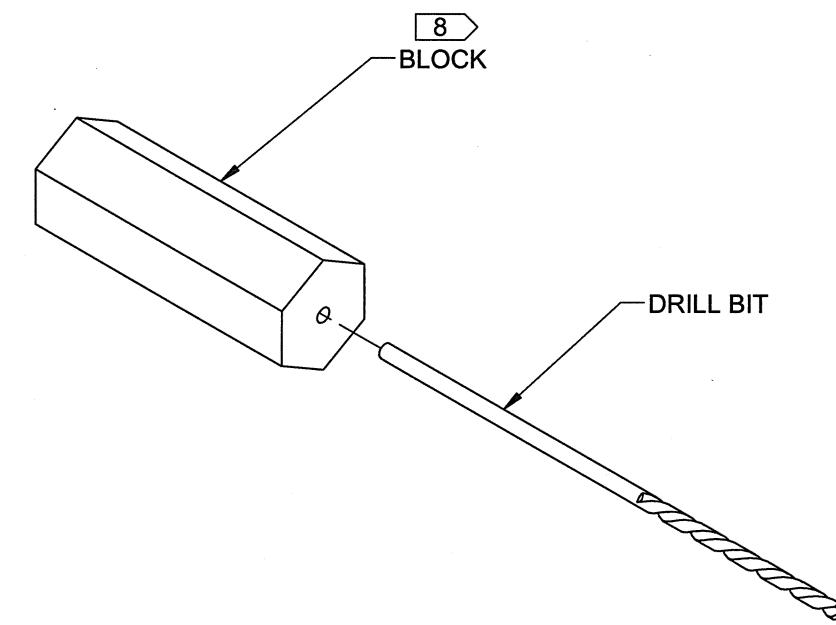
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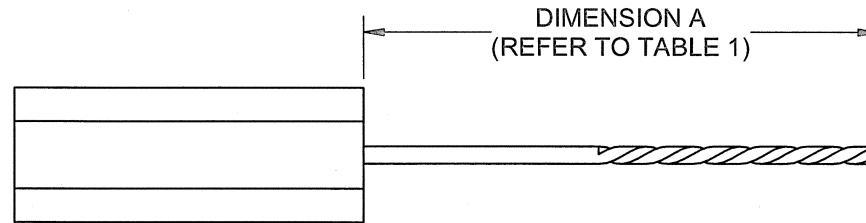
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ASSY QTY	ITEM #	PART #	PART TITLE				
			X	-3		RB23003267-3	#56 DRILL BIT ASSEMBLY
			1	-3A		RB23003267-3A	#56 DRILL BIT
D			1	-3B		RB23003267-3B	BLOCK
		X		-5		RB23003267-5	#52 DRILL BIT ASSEMBLY
		1		-5A		RB23003267-5A	#52 DRILL BIT
		1		-5B		RB23003267-5B	BLOCK
		X		-7		RB23003267-7	#27 DRILL BIT ASSEMBLY
		1		-7A		RB23003267-7A	#27 DRILL BIT
		1		-7B		RB23003267-7B	BLOCK
	X			-9		RB23003267-9	#22 DRILL BIT ASSEMBLY
	1			-9A		RB23003267-9A	#22 DRILL BIT
	1			-9B		RB23003267-9B	BLOCK
X				-11		RB23003267-11	#12 DRILL BIT ASSEMBLY
1				-11A		RB23003267-11A	#12 DRILL BIT
1				-11B		RB23003267-11B	BLOCK



**TABLE 1  
DRILL BIT ASSEMBLY**

PART #	DIMENSION A
RB 23003267-3	1.38
RB 23003267-5	1.25
RB 23003267-7	3.13
RB 23003267-9	2.63
RB 23003267-11	3.15



**RB23003267-3, -5, -7, -9 & -11 DRILL BIT ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°

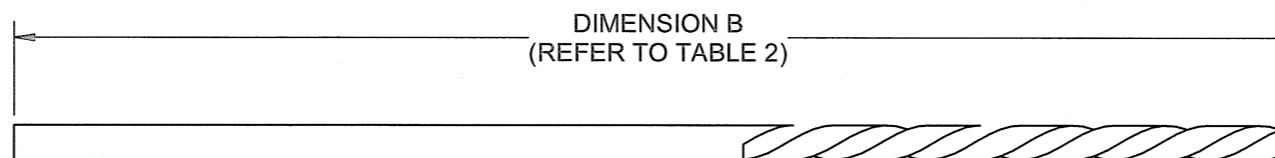
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY INSTANT ADHESIVE LOCTITE 495 BETWEEN THE SURFACES OF BLOCK AND DRILL BIT, AND REMOVE EXCESS

DESIGN	MBB	<b>DART AEROSPACE LTD</b>	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	
MFG. APPR.	FK	RB23003267	REV. E
APPROVED	WJ	TITLE	SHEET 3 OF 7
DATE 4/30/2019		POWER TURBINE CLEANING KIT C-18, C-20 & C-28	NTS
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**TABLE 2  
DRILL BIT**

PART #	PURCHASE DRILL BIT P/N (ARONSON CAMPBELL)	DIMENSION B
RB23003267-3A	AC40156	1.73
RB23003267-5A	AC40152	1.76
RB23003267-7A	AB51127	3.96
RB23003267-9A	AC40122	3.13
RB23003267-11A	AC40112	3.46

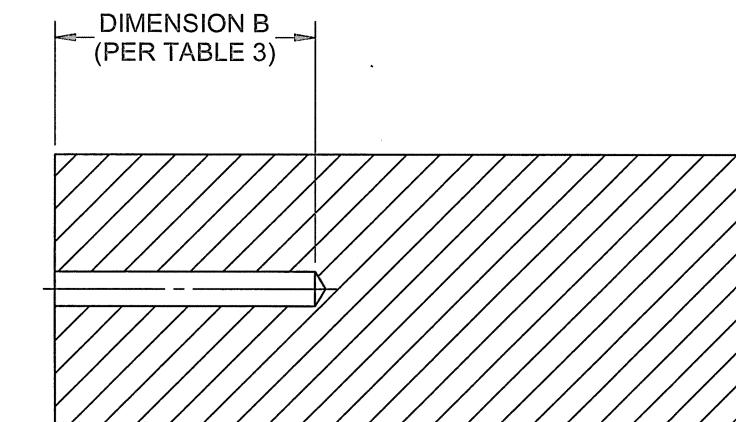
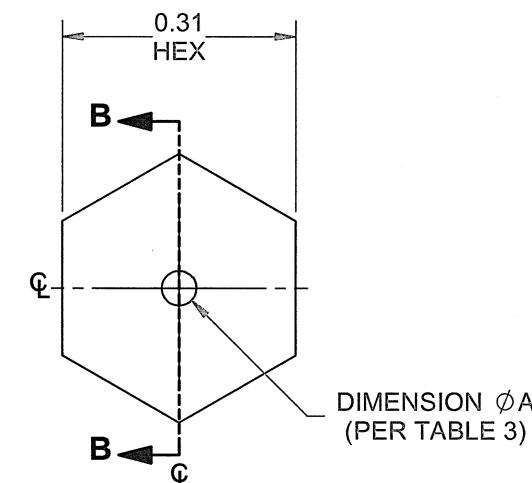
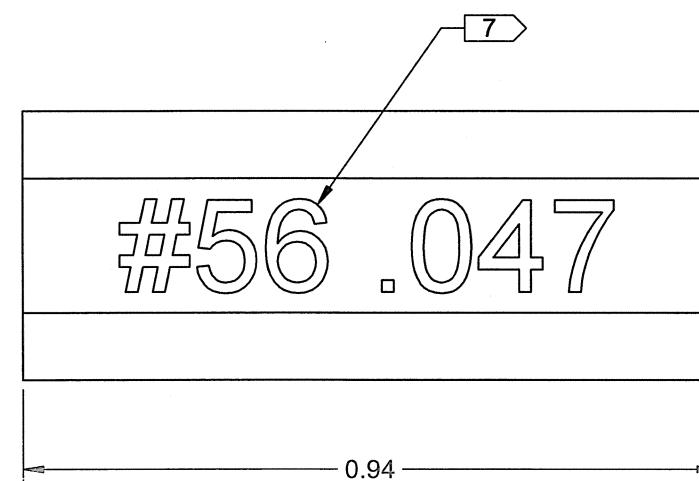

**RB23003267-3A, -5A, -7A, -9A & -11A DRILL BIT**
**NOTES:**

- 1) MATERIAL: REFER TO TABLE 2
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	MBB	<b>DART AEROSPACE LTD</b>	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT		
MFG. APPR.	FK		
APPROVED	WY		
		TOOL PART #	REV. E
		RB23003267	SHEET 4 OF 7
		TITLE	
		POWER TURBINE CLEANING KIT C-18, C-20 & C-28	NTS
		SCALE	—
DATE 4/30/2019			
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**TABLE 3  
BLOCK**

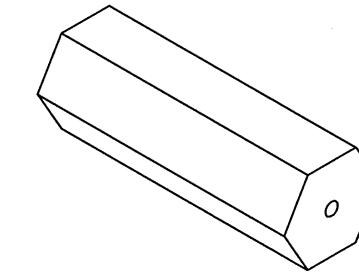
PART #	DIMENSION ØA	DIMENSION B	MACHINE ENGRAVE IDENTIFICATION
RB23003267-3B	0.047	0.35	#56 .047
RB23003267-5B	0.064	0.51	#52 .063
RB23003267-7B	0.144	0.83	#27 .144
RB23003267-9B	0.157	0.50	#22 .157
RB23003267-11B	0.189	0.31	#12 .189


**SECTION B-B**
**RB23003267-3B, -5B, -7B, -9B & -11B BLOCK**  
(RB23003267-3B SHOWN)

**NOTES:**

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE AS SHOWN PER TABLE 3

DESIGN	MBB	<b>DART AEROSPACE LTD</b>	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. E
MFG. APPR.	FK	RB23003267	SHEET 5 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
		POWER TURBINE CLEANING KIT C-18, C-20 & C-28	NTS
DATE	4/30/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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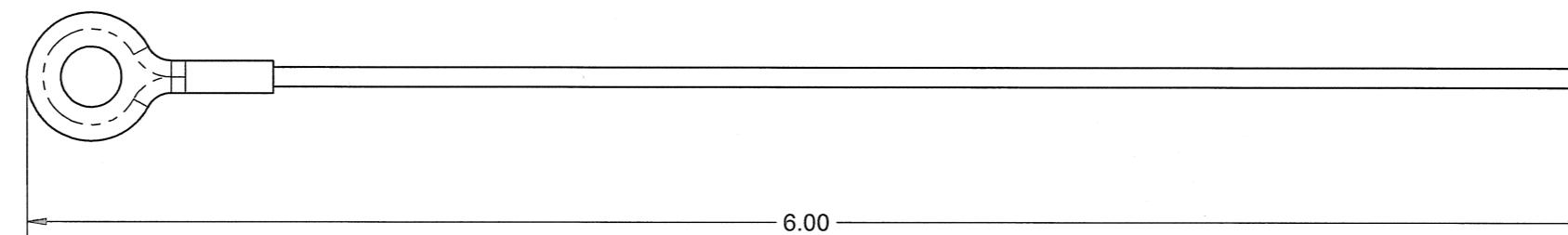
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**NOTES:**

- 1) MATERIAL: HAC5012BX OR EQUIV. (12" CARBIDE ROD SAW)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
 X.XX = +/- 0.01" / +/- 0.5°  
 X.XXX = +/- 0.005" / +/- 0.1°  
 X.XXXX = +/- 0.0005" / +/- 0.05°  
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

**RB23003267-13 SAW**

DESIGN	MBB	<b>DART AEROSPACE LTD</b>	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT		
MFG. APPR.	FK		
APPROVED	<i>[Signature]</i>		
		TOOL PART #	REV. E
		<b>RB23003267</b>	SHEET 6 OF 7
		TITLE	SCALE
		POWER TURBINE CLEANING KIT C-18, C-20 & C-28	NTS
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DATE 4/30/2019

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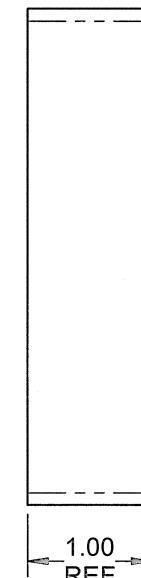
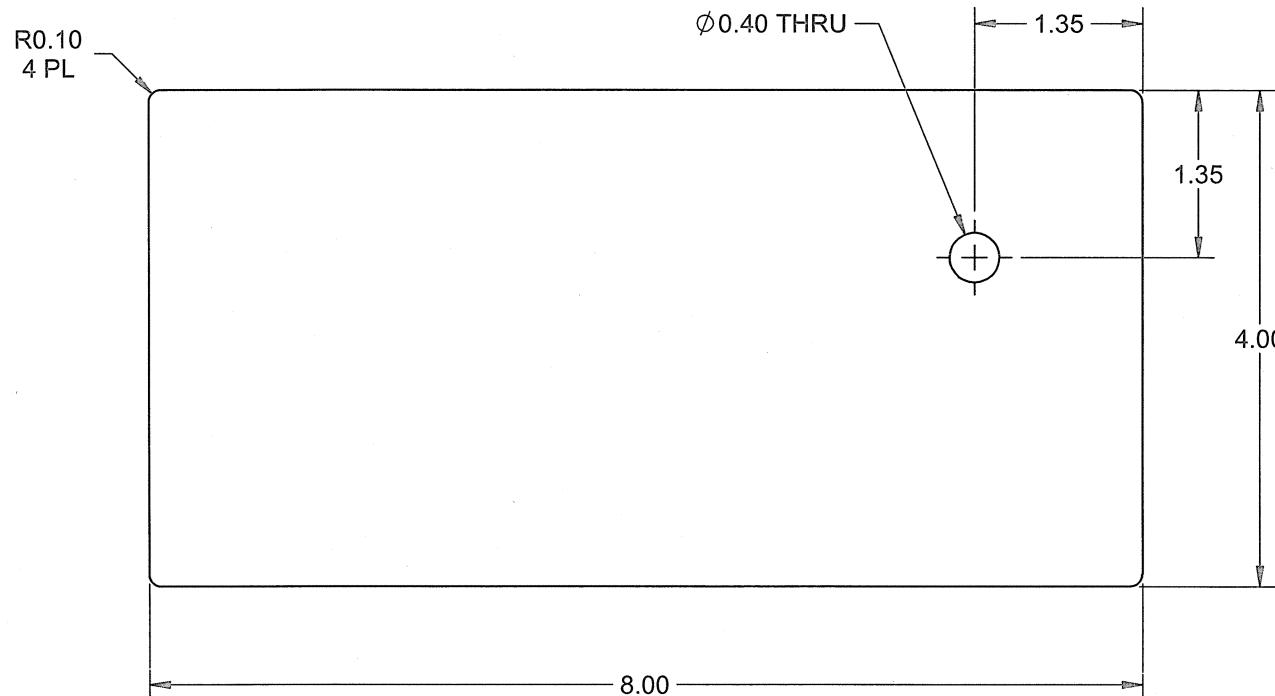
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### RB23003267-19 CRAFT FOAM

#### NOTES:

- 1) MATERIAL: McMaster#1887T48 OR EQUIV. (OIL-RESISTANT BUNA-N FOAM 1.00" THK.)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A

DESIGN	MBB	<b>DART AEROSPACE LTD</b>	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT		
MFG. APPR.	FK		
APPROVED	<i>[Signature]</i>		
		TOOL PART #	REV. E
		<b>RB23003267</b>	SHEET 7 OF 7
		TITLE	SCALE
		POWER TURBINE CLEANING KIT C-18, C-20 & C-28	NTS
DATE 4/30/2019			

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